

Work Order ID 132101

Friday, April 24, 2015 1:54:03 PM

132101

AOG - ship Monday

Item ID: D2580-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 205 Skidtube Assembly

Start Date: 4/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/27/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MFDate: 15-4-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

E

240

0.00

240

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D205-634-041 X 1 B131593

REMOVE GASKETS AND WEARPLATES AND RETURN TO STOCK
UNDER ORIGINAL BATCH NUMBER

PURPOSE OF THIS IS TO MAKE INTO A D2580-041 FOR SO121198

1x d all 5/04/27

250

0.00

250

HandFinish

Memo

0.00

Hand Finishing

REMOVE GASKETS AND WEARPLATES:

D3564-11 X 1 B128226 ✓

D3564-13 X 1 B129543 ✓

D3564-5 X 1 B129544 ✓

D3564-9 X 1 B129545 ✓

D3566-1 X 2 B131397 ✓

D3566-13 X 1 B130334 ✓

D3566-5 X 1 B130333 ✓

AND PUT BACK INTO STOCK

1x d all 12/04/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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Work Order ID 132101

Friday, April 24, 2015 1:54:03 PM

132101

Page 2

Item ID: D2580-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 205 Skidtube Assembly
Start Date: 4/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/27/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									DAS
QC	Memo	0.00							9
Quality Control									9-89
270	Identify as per dwg & Stock Location: _____	0.00							
270									DAS
Packaging	Memo	0.00							63
Packaging									9-89
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

APR 27 2015

MWS 15-04-27

MF
15-4-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Friday, April 24, 2015 1:54:01 PM

Page 1

Work Order ID: 132101

132101

Parent Item: D2580-041

D2580-041

Parent Item Name: 205 Skidtube Assembly

Start Date: 4/24/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-634-041		Manufactured	No				Each	3.0000		1			

D205-634-041

Replacement Skidtube with Standard Wearplates Fits LH or RH

Location	Loc Qty	Loc Code
FG	1	
130436	1	
FG073	2	
131592	1	
131593	1	
	Each	23.0000

D3564-11

Manufactured No

D3564-11

Wearplate Aft

Location	Loc Qty	Loc Code
FG	6	
77056	4	
85473	2	
FP001	5	
128226	5	
FP002	12	
129542	12	
	Each	14.0000

D3564-13

Manufactured No

D3564-13

Wearpad Fwd

Location	Loc Qty	Loc Code
FG	2	
89044	2	
FP001	12	
129543	12	

MF 15-4-24.

-1

12/04/27

x1

-1

12/04/27

x1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Page 2

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D2580-041

Parent Item Name: 205 Skidtube Assembly

Start Date: 4/24/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

Each

28.0000

-1

D3564-5

Wearplate Center

all 12/04/27

Location

Loc Qty

Loc Code

FG

4

34806

2

89048

2

FP002

24

126310

1

129544

12

130495

11

X1

D3564-9

Manufactured No

Each

14.0000

-1

D3564-9

Wearplate Fwd

all 12/04/27

Location

Loc Qty

Loc Code

FG

6

76950

4

88407

2

FP002

8

129545

8

X1

D3566-1

Manufactured No

Each

27.0000

-2

D3566-1

Gasket Aft / Fwd

all 12/04/27

Location

Loc Qty

Loc Code

FG

14

100410

4

117012

4

89051

2

96430

2

98981

2

FP001

13

131397

13

X2

Friday, April 24, 2015 1:54:01 PM

Shop Packet Print

Page 2

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WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item Name: 205 Skidtube Assembly

Start Date: 4/24/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

Each

15.0000

-1

D3566-13

Gasket Fwd

**

all 5/04/20

Location

Loc Qty

Loc Code

FG

6

89050

2

92482

2

98908

2

FG001

9

130334

9

Each

18.0000

-1

D3566-5

Manufactured No

D3566-5

Gasket Center Aft

**

all 5/04/20

Location

Loc Qty

Loc Code

FG

4

89219

2

94119

2

FP001

14

130333

14

-1

*
ADD
ADD

NAS1149C0332R x 50 MBK697
AN364A x 50 MB131420

DAS

27

9-89

DAS

9

9-89

9-89

APR 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

LOT TRACKING !!

Parent Item ID /	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
ALS7-1032-130	131593	-50	M128649	4/23/2015 8:15:31 AM	\$.11
AN3-5A	131593	-2	m131420	4/23/2015 8:15:32 AM	\$.09
AN3C4A	131593	-50	M131803	4/23/2015 8:15:31 AM	\$.27
D2576-3	131593	-1	117905	4/21/2015 11:08:23 AM	\$31.37
D2580-1	131593	-1	131406	4/20/2015 7:48:17 AM	\$303.72
D2594-1	131593	-8	131092	4/24/2015 12:51:49 PM	\$2.32
D2594-1	131593	-8	119620	4/24/2015 12:51:49 PM	\$2.32
D2594-3	131593	-16	130546	4/23/2015 8:15:29 AM	\$.10
D2855	131593	-1	117602	4/24/2015 12:58:30 PM	\$18.37
D3564-11	131593	-1	128226	4/23/2015 8:15:30 AM	\$62.47
D3564-13	131593	-1	129543	4/23/2015 8:15:30 AM	\$8.45
D3564-5	131593	-1	129544	4/23/2015 8:15:30 AM	\$26.53
D3564-9	131593	-1	129545	4/23/2015 8:15:30 AM	\$67.08
D3566-1	131593	-2	131397	4/23/2015 8:15:30 AM	\$8.96
D3566-13	131593	-1	130334	4/23/2015 8:15:31 AM	\$3.46
D3566-5	131593	-1	130333	4/23/2015 8:15:30 AM	\$6.51
D4202-1	131593	-20	129565	4/20/2015 11:54:13 AM	\$2.67
NAS1149C0332R	131593	-50	m131697	4/23/2015 8:15:31 AM	\$.02
NAS1149D0332J	131593	-2	m131624	4/23/2015 8:15:32 AM	\$.04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								